

Date: Thursday, 3/23/2006 3:41:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 26347A	
Estimate Number : 10522	
P.O. Number : N/A	Part Number : D206642441
This Issue : 3/23/2006 S.O. No. : N/A	Drawing Number : D2650 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : D1
Previous Run : 24953A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/16/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.24</u>	
Comment : Est Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

DH 06-04-25

2.0	D2620	Bent 206 Skidtube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD BE 26450 BE 06-04-13 (1)

3.0	D2647	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap BE 20535 BE 06-04-13 (1)

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube BE 06-04-13 (1)

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 BE 06-04-13 (1)

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M18839/M19101 BE 06-04-13 (1)

4-Grind weld flush to cap on top surface only. BE 06-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



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	5-Cut aft end 138.60" from front of tube	BE 06-04-13
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	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".	BE 06-04-17
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	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".	BE 06-04-17
--	-----------------------------------------------------------------	-------------

	8-Open using #6 Drill Bit	BE 06-04-17
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	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail	BE 06-04-17
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	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650	BE 06-04-17
--	------------------------------------------------------------------------	-------------

	11-Deburr and Blow out all chips from inside the tube	BE 06-04-17
--	-------------------------------------------------------	-------------

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 06-04-17

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B26365 Pm' 06-04-17D

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) BE 06-04-17

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) BE 06-04-17

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. BE 06-04-17

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 06-04-17 Time: 4:00

Finish Date: 06-04-19 Time: 12:30

A/R Sikaflex-291 m100450

Sikaflex expiry date: 06-11-01

Pm' 06-04-17D

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Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-4-19

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B 24200 BE 06-4-19

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m18839 BE 06-04-19

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

BE 06-04-19

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

BE 06-04-19

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B 24203 BE 06-04-25

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

m18548 BE 06-04-25

W/O:		WORK ORDER CHANGES					
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Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	M7885343	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

m19099 BE 06-04-25

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 06-04-25

15.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

[Signature] D 06-04-26

16.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

DL 06/06/02 (1)

17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 06-06-05 (1)

18.0	D26483	Wearpad
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B25904

19.0	D265615	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B21712

DL 06/06/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 26347A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B22085

21.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B23558

22.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B24417

23.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M18293

or (see QSI 017)

24.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M18235

PL 06/06/07 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 26347A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	MS27039108	Screw
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Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
60	MS27039-1-08	Screw	M18836

26.0	D26511	Plug
------	--------	------



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
22	D2651-1	Plugs	B25365

27.0	D26513	O-Ring
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Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
22	D2651-3	O-Rings	B25978

28.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416	Washer	M11151

29.0	MS27039406	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS27039-4-06	Screw	M6874

DL 06/06/07 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26347A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B25381

31.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M18235

32.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M18836

DL 06/06/07 (1)

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M101126

Sikaflex expiry date:

11/06

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M101126

Sikaflex expiry date:

11/06

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M100652

DL 06/06/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DE Date: 02/02/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 26347A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

FC 06 06 08

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FG17

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

IP 06/06/09

Job Completion



u 06/06/09

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2650	REV. D SHEET 1 OF 5
DATE 04.05.17		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	

RELEASED
04.06.22 *HH*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26347A

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Dart Aerospace Ltd

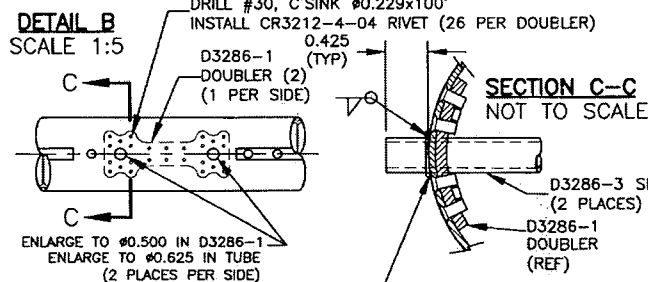
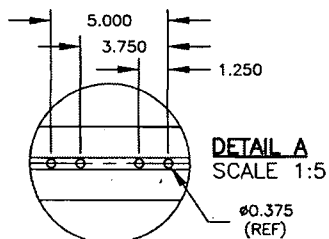
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

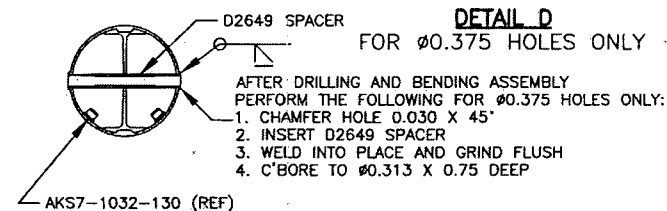
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

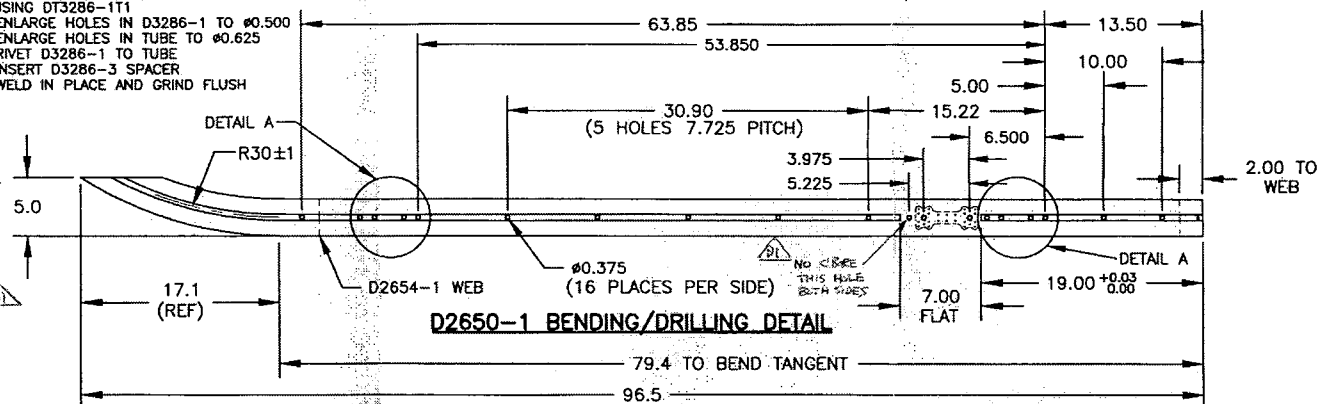
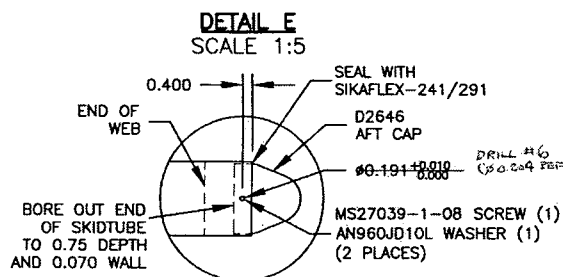


SECTION C-C NOT TO SCALE



RELEASED
01.06.22

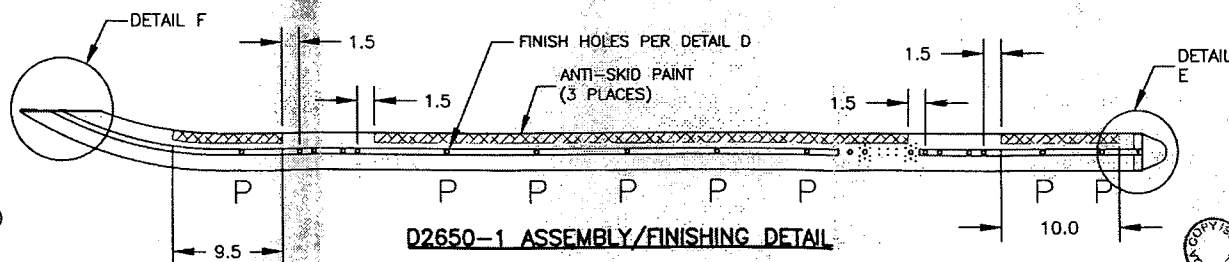
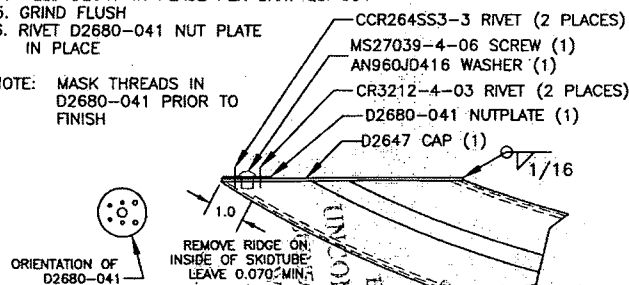
- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



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CHECKED	APPROVED	DATE	DRAWING NO.	REV. D	
04.05.17			D2650	SHEET 2 OF 5	
			TITLE	SCALE	
			SKIDTUBE	1:10	

WORK ORDER
063477A
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RETURN TO
ENGINEERING
FOR NOTICE
TO AMENDMENT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
26347A

Dart Aerospace Ltd

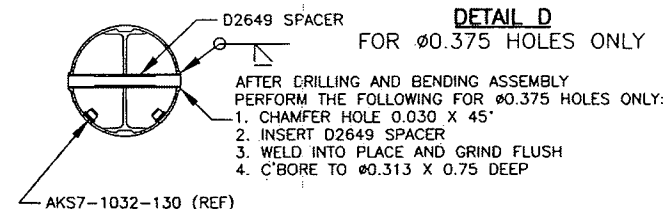
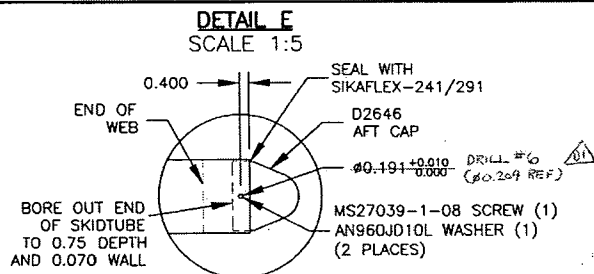
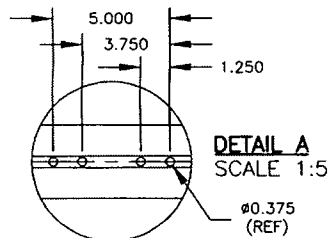
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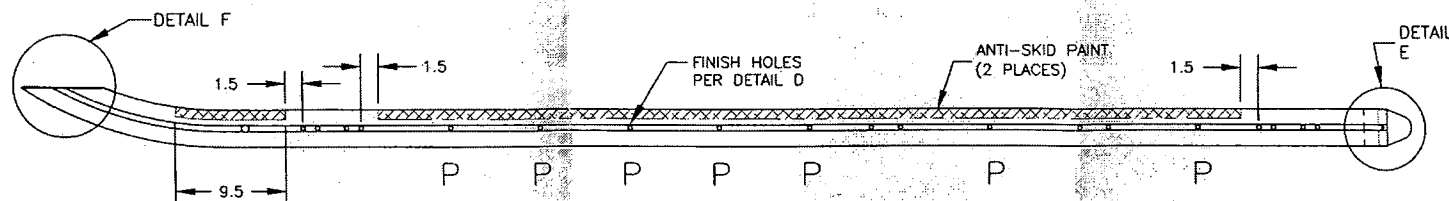
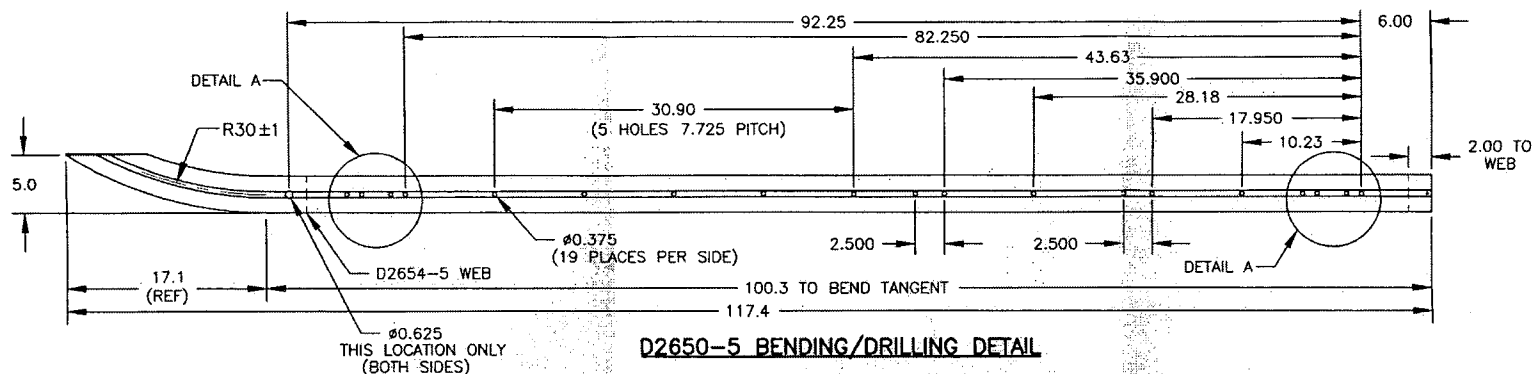
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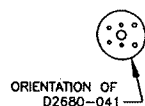
RELEASED



DETAIL F (NOT TO SCALE)

- CUT TUBE LEVEL
- REMOVE RIDGE ON FWD SIDE
- LOCATE D2647 (TRIM AS NECESSARY)
- WELD D2647 IN PLACE PER DART QSI 004
- GRIND FLUSH
- RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.

- CCR2645S3-3 RIVET (2 PLACES)
- MS27039-4-06 SCREW (1)
- AN960JD416 WASHER (1)
- CR3212-4-03 RIVET (2 PLACES)
- D2680-041 NUTPLATE (1)
- D2647 CAP (1)

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DESIGN
CHECKED
DATE
04.05.17

DRAWN BY
APPROVED

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO.
D2650
TITLE
SKIDTUBE
REV. D
SHEET 4 OF 5
SCALE
1:10

Dart Aerospace Ltd

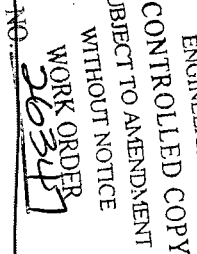
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